

Work Order ID 111875

January-24-14 7:30:58 AM

111875

Page 1

Item ID: D2651-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Plug

Stop

NS2

Start Date: 1/24/14

Start Qty: 200.00

200

Cust Item ID:

Required Date: 1/27/14

Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2651

Rev B

100

0.00

100

Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1- Turn as per Folio FA219 and Dwg D26512- Deburr

ET 14-01-29 (X 200)

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

ET 14-01-29

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

B-A 14/01/30

200

φ

DAS
08
2-89



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Item ID: D2651-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plug
Start Date: 1/24/14 Start Qty: 200.00 ***200*** Cust Item ID:
Required Date: 1/27/14 Req'd Qty: 200.00 ***200*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating	(Only larger section necessary)START TIME: 3:20								
	320 OVEN TEMPERATURE: 3:50 FINISH								
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00							
Quality Control									

200 76 14-1-30

200 14-2-4. DAS 34 9-89

200 14-02-05 DAS 9 9-89

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Item ID: D2651-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Plug
 Start Date: 1/24/14 Start Qty: 200.00 *200* Cust Item ID:
 Required Date: 1/27/14 Req'd Qty: 200.00 *200* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <u>FP-600</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

200 x 1 14-02-05

MLJ 14-02-05

(U) 14-02-05

Picklist Print

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Work Order ID: 111875

Parent Item: D2651-1

Parent Item Name: Plug

Start Date: 1/24/14

Required Date: 1/27/14

Start Qty: 200.00

Required Qty: 200.00

Comments: IPP: A02.04.15New Issue NG
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500 6061-T6 Round Bar .500"		Purchased	No			100	f	11.3000	0.0401	9			

Location

Loc Qty

Loc Code

MAT012

11.3

124029

1

125552

10.3

RT 14-01-29

10.3

m6061T6R0.503
c24161129

x.5

m126852

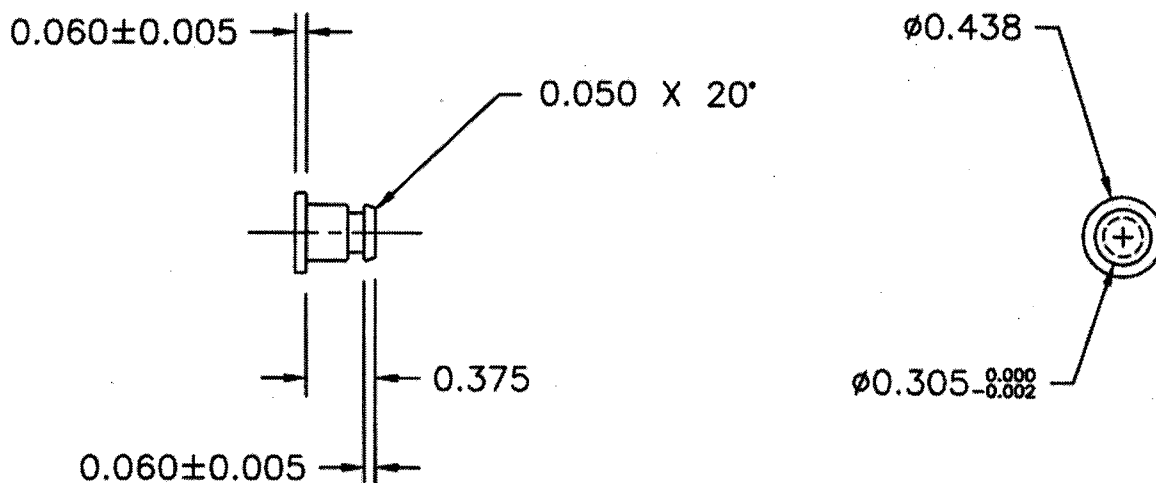
x.5



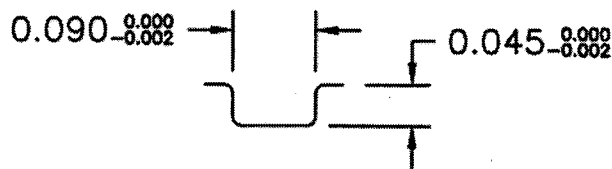
DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

RELEASED
03.12.19 #

D2651-1 PLUG:



GROOVE DETAIL (SCALE 5:1)



D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER
3/16" ID, 5/16" OD, 1/16" WIDTH
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

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